

Date: Thursday, 6/21/2007 2:34:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33087		
Estimate Number	: 12292		
P.O. Number	: <i>N/A</i>	Part Number	: D26513
This Issue	: 6/21/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 32577	Material	: <i>N/A</i>
Written By	:	Due Date	: 6/29/2007
Checked & Approved By	: <i>[Signature]</i> 07.06.22	Qty:	300 Um: Each
Comment	: est rev. A 06.02.15 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4022**07/06/22 300*

Purchase P/N: 2-008 as per Dwg D2651

Supplier: Parker

Ensure Certificate of Conformity is attached

2.0	MS28775008	O RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)

O RING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

[Signature] *07/07/03* *(300)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3446

En 07/07/03 *(297)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F-1118 HING*
[Signature] *07/7/9* *(297)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33087

Part Number: D26513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



297

Comment: FINAL INSPECTION/W/O RELEASE

207107109

Job Completion



207107109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

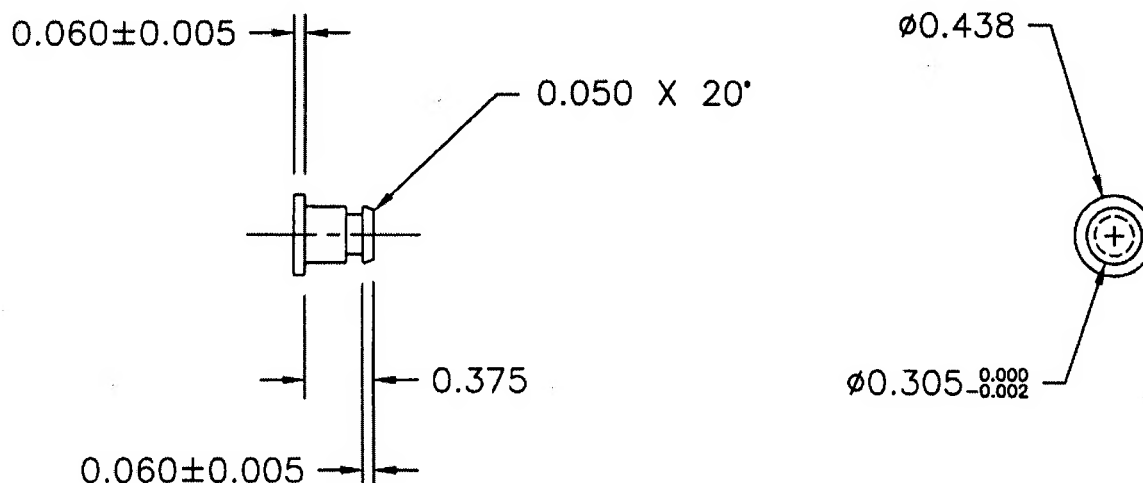


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

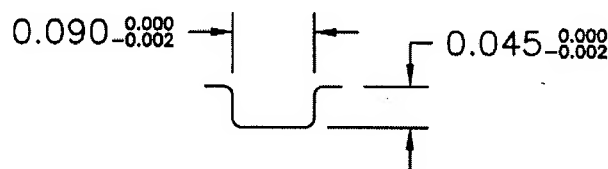
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33087

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Parker Hannifin Corporation

O-Ring Division

Parker Seal de Matamoros

Diagonal Lorenzo De La Garza #13 Ciudad

H. Matamoros, Tam. 87499, Mexico

Phone: (859) 335-3000

— NOTICE —

This is a C.B.I. Compound!

C.B.I. is Parker's exclusive quality assurance program for Controlled Batch Identification, your assurance of reliability.

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 179577 received by us from SWAN ENGINEERING & SUPPLY is traceable to C.B.I. Number 0080041710 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

CUSTOMER PART NUMBER	PARKER PART NUMBER	COMPOUND	QUANTITY	CURE DATE	SHIP DATE
MS28775-008	MS28775-008	N0304 -75	6288	2Q06	05/11/06
TESTED AS: 2-214 & BUTTONS					
PHYSICAL PROPERTIES	REQUIREMENTS	VARIATION	PARKER FINDINGS		
SPECIFICATION MIL-P-25732c	TYPE	CLASS	TEST DT 04/26/06		
ASTMD297 SPECIFIC GRAVITY			(1.26 - 1.30)	1.2800	
ASTMD2240 HARDNESS SHORE A	(68 - 80)		(70 - 80)	73	
ASTMD1414 TENSILE STRENGTH, PSI	1350 MIN		(1440 - 2160)	1543	
ASTMD1414 ELONGATION, %	160 MIN		(160 - 226)	187	
MODULUS AT 100% ELONG.	500 MIN		(500 - 9999)	569	
TR-10 50% ELONG. 10% RETURN	-49 MAX			-55.0	
FLUID AGEING 70 HRS AT 275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX	55			34.0	
TR-10	-49 MAX			-49.0	
ASTMD2240 HARDNESS CHANGE	+5 -15			-10.0	
VOLUME CHANGE	1 +20			15.0	

Testing Performed By PSDM Lab
Diagonal Lorenzo De La Garza #13 Ciudad
H. Matamoros, Tam. 87499, Mexico

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

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O-Ring Division
PARKER HANNIFIN CORPORATION

By



Ruben Ramirez
Quality Assurance Manager

